

Work Order ID 152029

Wednesday, October 19, 2016 8:27:01 AM

152029

Page 1

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 10/21/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/28/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: OCT 19 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3885

C

0.00

108

108

Purchasing

Purchasing

Memo

Purchasing

Issue P/O:

Supplier: WEJAY

Machine as per Dwg D3885

Conformity sheet required

334.64

OCT 20 2016

DAS
13
9-89

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

0.01

Lex. SP/6-11-4.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 152029***152029***

Page 2

Wednesday, October 19, 2016 8:27:01 AM

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 10/21/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/28/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.02

Quality Control

USE DT10253 INSPECTION TEMPLATE

DAS
38
9-89
NOV 15 2016

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.17

Hand Finishing

x6  2016/11/15
BEB

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.01

Quality Control

DAS
03
9-89 16-11-15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 152029

Wednesday, October 19, 2016 8:27:01 AM

152029

Page 3

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 10/21/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/28/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.01

Packaging

LOCATION : LG002

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.10

Quality Control

DAS
21
9-88

NOV 15 2016

16-11-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

Picklist Print

Wednesday, October 19, 2016 8:27:06 AM

Page 1

Work Order ID: 152029

152029

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 10/21/2016

Required Date: 10/28/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-1P		Purchased	No				Each	0.0000		6			
D3885-1P									**				
Standard Web													
D3882-1-130		Manufactured	No			110	Each	6.0000	1	6			
D3882-1-130									**				
Extrusion "I" Beam													

6x SD/b-11-14
DAS
13
9-89
OCT 20 2016

Location

WEJAY

137403

Loc Qty

6

6

Loc Code

✓

DQA: _____ Date: _____

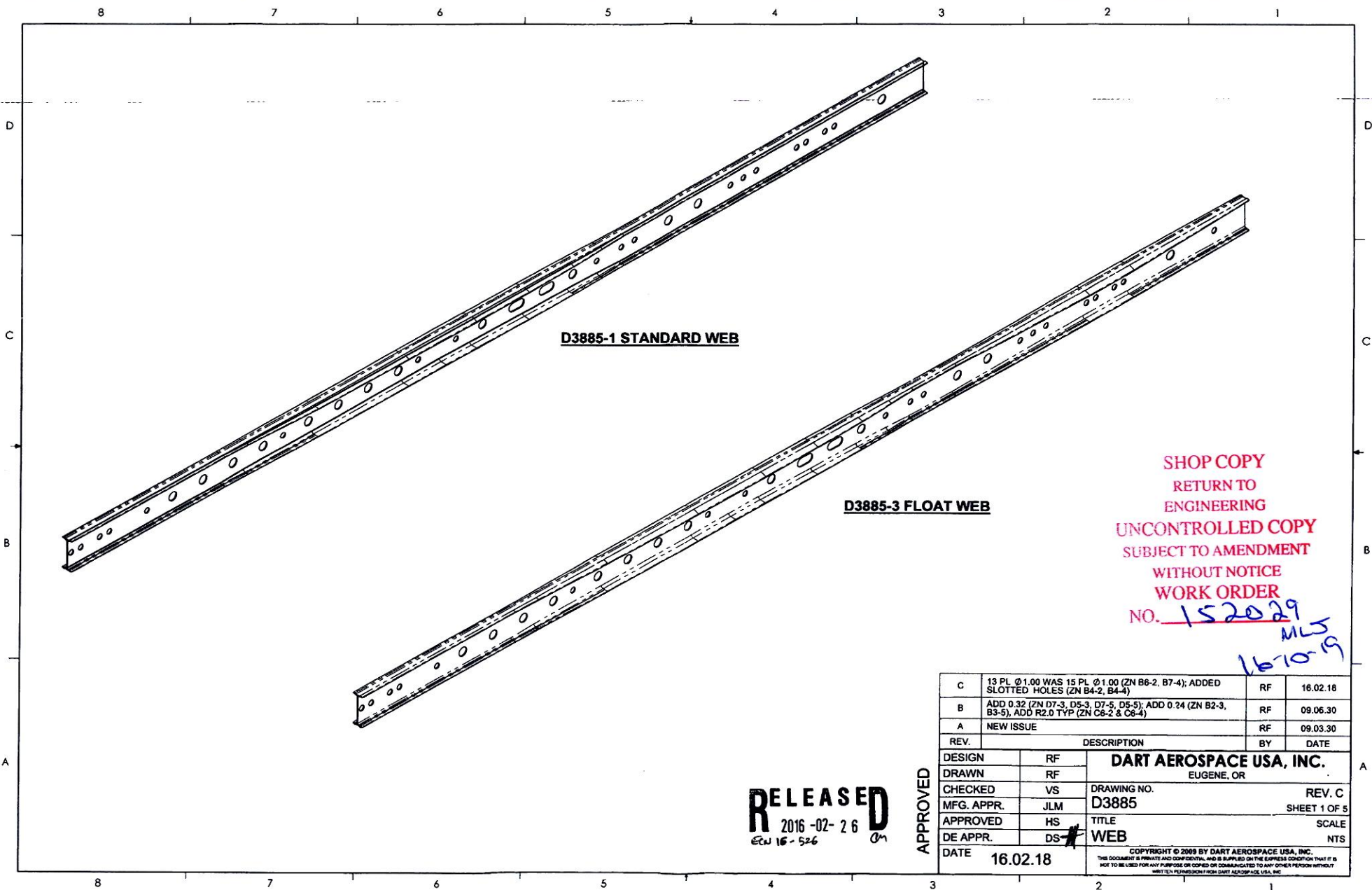
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152029
MLJ
16-10-19

C	13 PL Ø1.00 WAS 15 PL Ø1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	DRAWING NO. D3885 REV. C SHEET 1 OF 5	
DATE	16.02.18	TITLE WEB SCALE NTS	
COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

RELEASED
2016-02-26
ECW 16-526

APPROVED

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



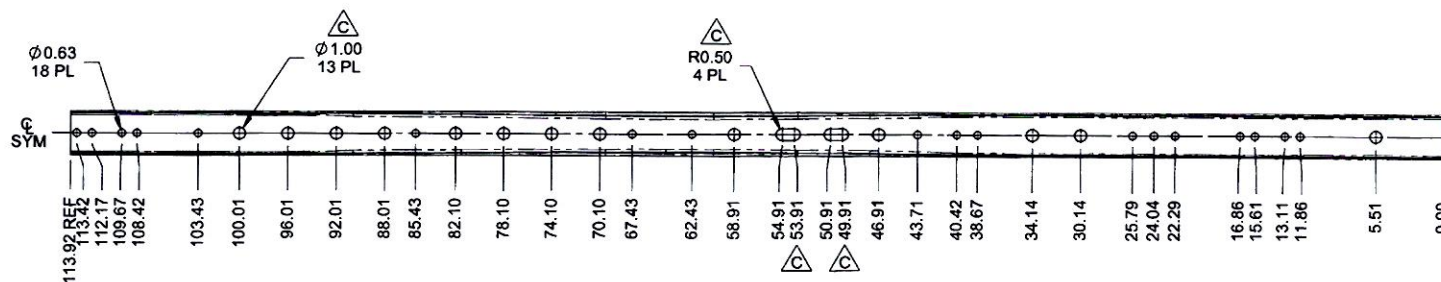
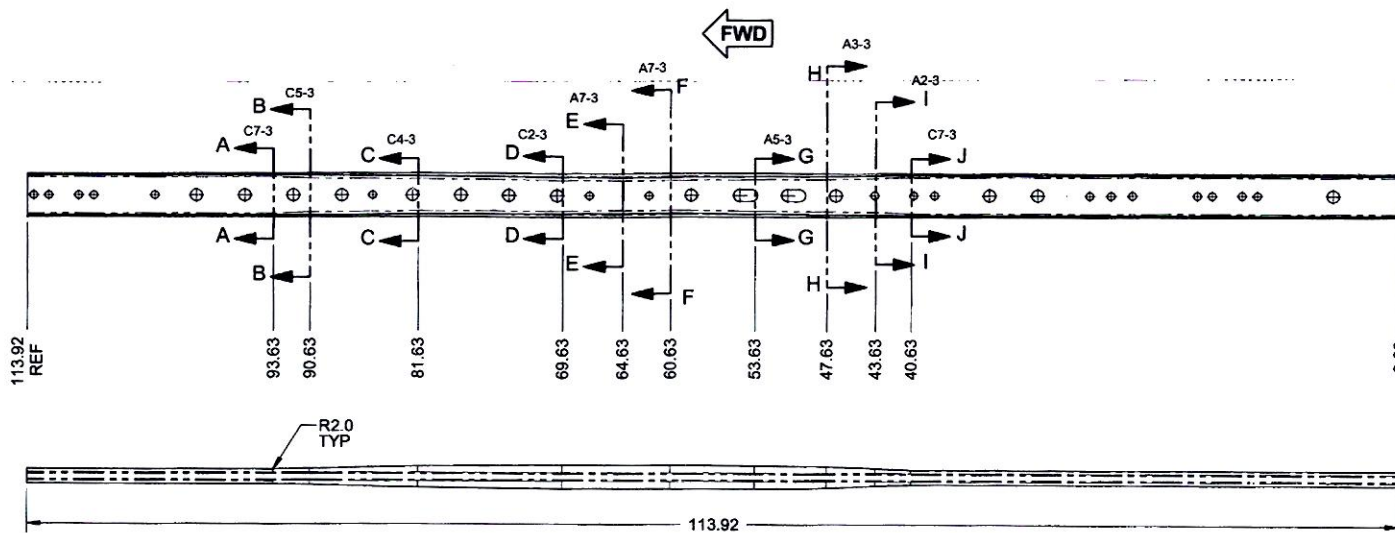
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

8 7 6 5 4 3 2 1



D3885-1 STANDARD WEB

D3885-1 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.49 lbs

RELEASED
2016-02-26

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	16.02.18

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO.	REV. C
D3885	SHEET 2 OF 5
TITLE	SCALE
WEB	NTS

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1

DQA: _____ Date: _____

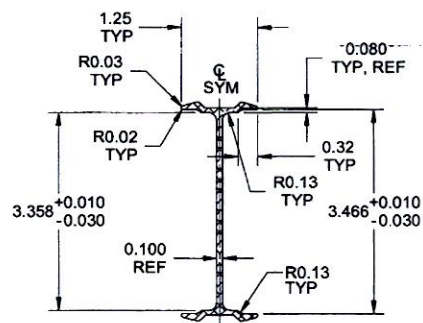
WORK ORDER NON-CONFORMANCE / UPDATE



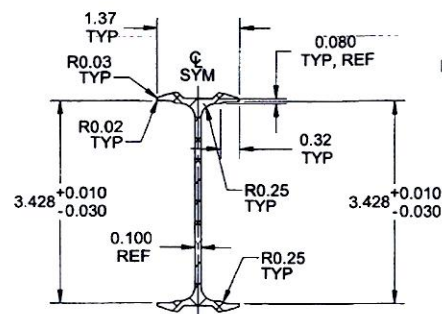
QA Closed: _____ Date: _____

Work Order update only ☐

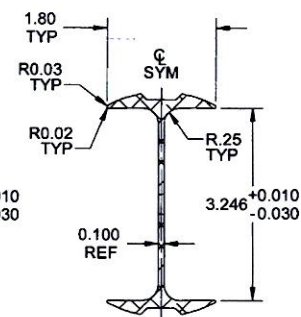
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



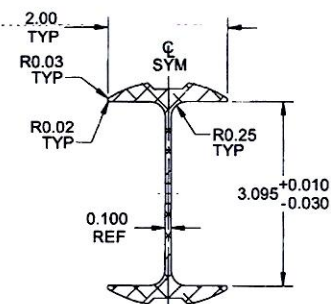
**SECTION A-A
& SECTION J-J**
SCALE 5X
D6-2
D4-2



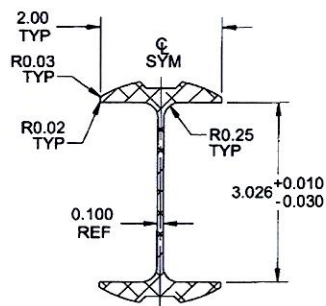
SECTION B-B
SCALE 5X
D6-2



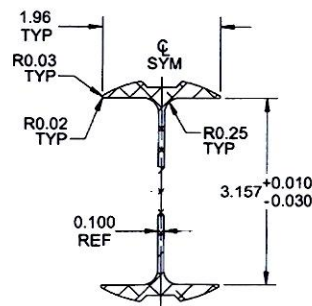
SECTION C-C
SCALE 5X
D6-2



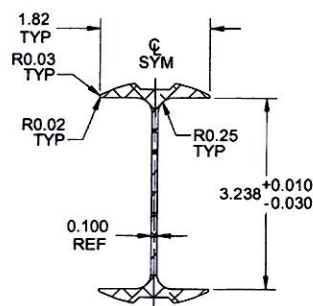
SECTION D-D
SCALE 5X
D6-2



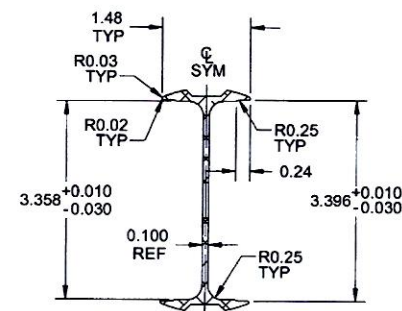
**SECTION E-E
& SECTION F-F**
SCALE 5X
D6-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2



SECTION I-I
SCALE 5X
D4-2

D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____

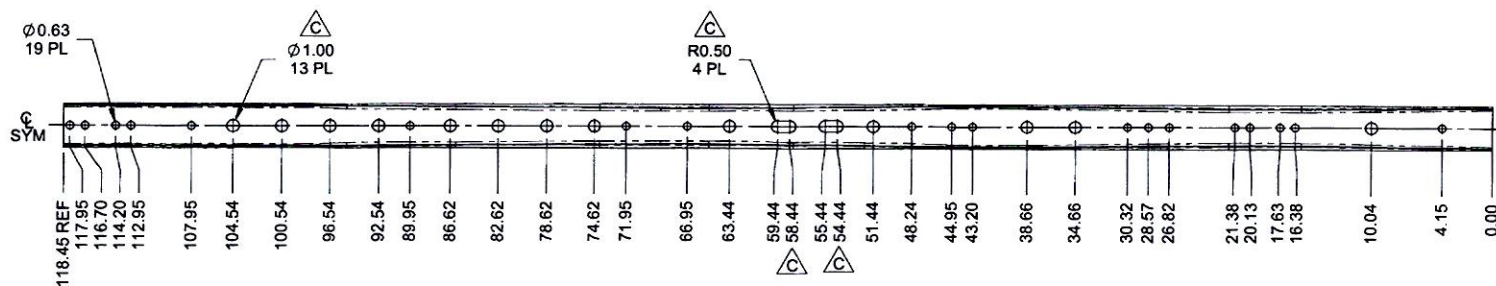
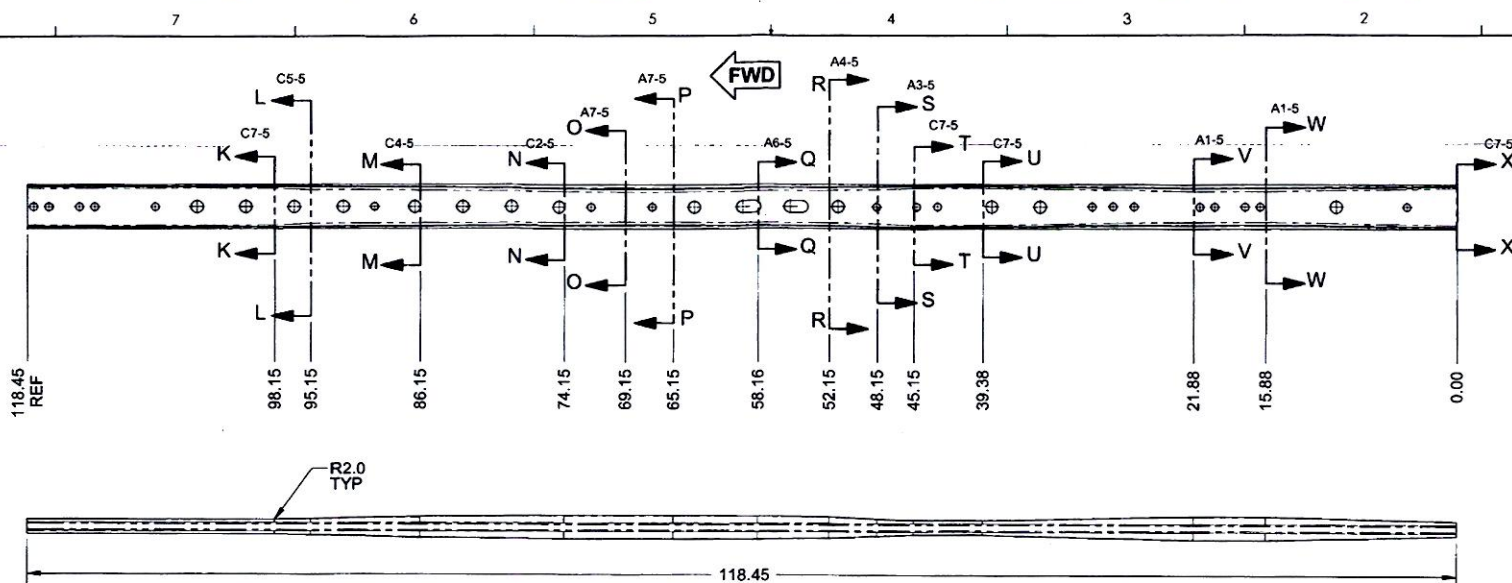
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



D3885-3 FLOAT WEB

D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 004 6.1
- 7) WEIGHT: 10.14 lbs

RELEASED
2016-02-26

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	16.02.18

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO.	REV. C
D3885	SHEET 4 OF 5
TITLE	SCALE
WEB	NTS

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

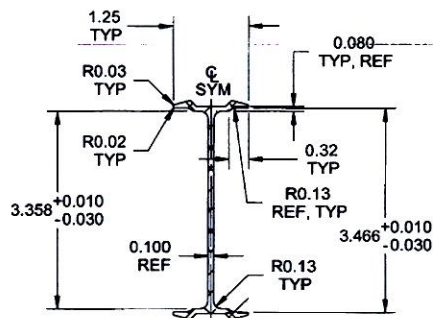


QA Closed: _____ Date: _____

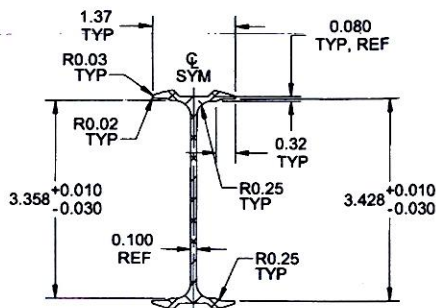
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

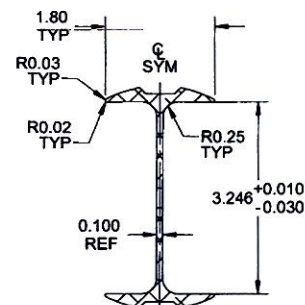
8 7 6 5 4 3 2 1



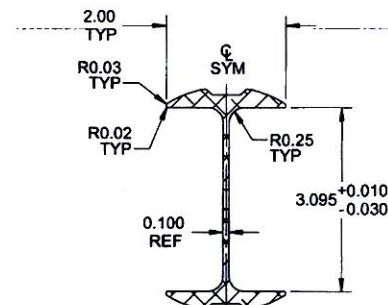
**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X
D7-4
D4-4
D3-4
D1-4



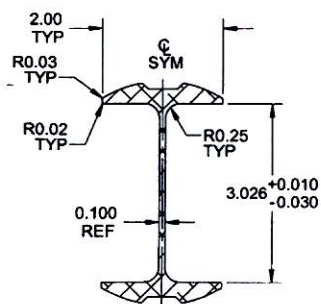
SECTION L-L D6-4
SCALE 5X



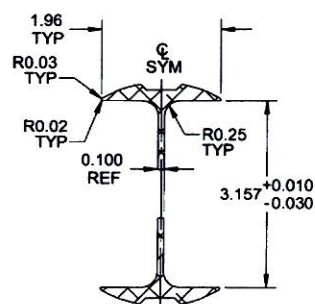
SECTION M-M D6-4
SCALE 5X



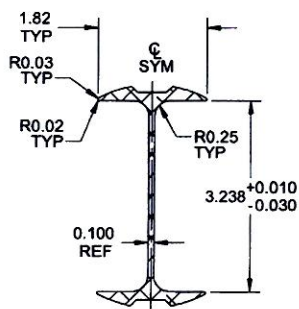
SECTION N-N D5-4
SCALE 5X



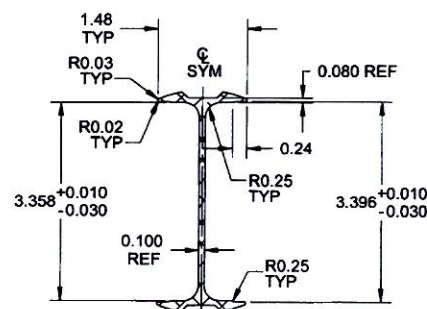
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



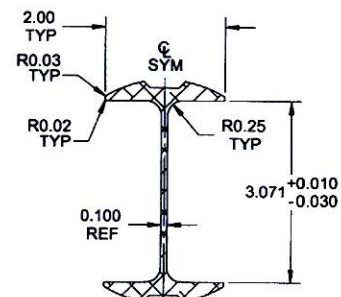
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34011

Purchase Order Date 10/20/2016

PO Print Date 10/20/2016

Page Number 1 of 2

Order From :

VC-WMP001

Ship To : DART AEROSPACE LTD

OCT 21 2016

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone

613-384-1662

Ship To Contact

Ship To Phone

Ship Via:

Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D3885-1P	Standard Web	11/17/2016		6.00	\$550.00	\$3,300.00
			Yes		Each		
			11/17/2016				
	AS PER DWG D3885 REV. C						
	B152029						
		DAS 38 9-88					
Line Total:							\$3,300.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	11/17/2016		1.00	\$0.00	\$0.00
			No				
			11/17/2016				
	Procurement Quality Clauses						
	A005 RIGHT OF ENTRY						
	A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER,						
	(DOCUMENTATION MAINTAINED BY SUPPLIER)						
	A016 PERSONNEL QUALIFICATION						
	A024 PROCESS CERTIFICATIONS						
	A025 CERTIFICATE OF CONFORMANCE						
	A040 NOTIFICATION OF QUALITY ESCAPE						
	A042 DART NOTIFICATION BY SUPPLIER						
	A043 RETENTION OF QUALITY DOCUMENTS						

Note:

10/20/2016

NOV 14 2016

DAE
26
9-88

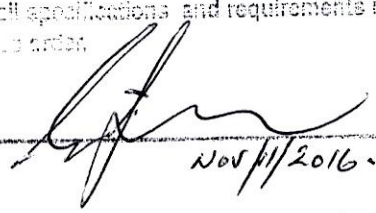


Packing Slip 38274

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

S
O
L
D
T
O
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

S
H
I
P
T
O
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

INVOICE DATE		YOUR ORDER NO. 34011		DATE ORDERED 10/31/16		SHIPPED VIA BEST WAY	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
	-	6	Fabricate standard web as per drawing D3635, Rev. C 10000.00				
			RT150000				
			required by: November 17, 2016				
			NOV 11 2016				
			RELEASE NOTE				
			I certify that the items listed herein have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.				
			Inspection Supervisor  Nov 11/2016				
			G.S.T.				
			P.S.T.				
ORDER: COMPLETE ☐ PARTIAL ☐						TOTAL	

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Nov. 11, 2016	
		P.O.# 34011	
		WEJAY JOB# 38274	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-P1 (Standard Web)	6	Machine supplied extrusion material to	D3885 sheets 2-3
		Drawing req'ts	Rev.C
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

A handwritten signature in black ink, appearing to be 'CS' or similar initials, followed by a horizontal line.

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38274

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 34011

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. —

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

Paul Rousen/Ed Jansen

QUANTITY

ACCEPT:

REJECT:

N.C.R.#

DATE:

REC'D: 6

--

Nov. 11, 2016

INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / FINAL INSPECTION

Dimension's marked s with '*' are out of tolerance due to condition of supplied extrusion material. Please review and advise.

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Ø .63"	18 places	+.008/-.001		0.63		Acc.
2	Hole, Ø 1.00"	13 places	+.010/-.001		1.001		Acc.
3	Slot, R 0.50	4 places	+.010/-.001		.500		Acc.
4	5.51"		□ .03		5.511		Acc.
5	11.86"		□ .03		11.852		Acc.
6	13.11"		□ .03		13.101		Acc.
7 15.	15.61"		□ .03		15.600		Acc.
8	16.86"		□ .03		16.850		Acc.
9	22.29"		□ .03		22.287		Acc.
10	24.04"		□ .03		24.036		Acc.
11	25.79"		□ .03		25.785		Acc.
12	30.14"		□ .03		30.126		Acc.
13	34.14"		□ .03		34.125		Acc.
14	38.67"		□ .03		38.657		Acc.
15	40.42"		□ .03		40.406		Acc.
16	43.71"		□ .03		43.698		Acc.
17	46.91"		□ .03		46.894		Acc.
18	49.91"		□ .03		49.895		Acc.
19	50.91"		□ .03		50.895		Acc.
20	53.91"		□ .03		53.896		Acc.
21	54.91"		□ .03		54.896		Acc.
22	58.91"		□ .03		58.897		Acc.
23	62.43"		□ .03		62.421		Acc.
24	67.43"		□ .03		67.420		Acc.
25	70.10"		□ .03		70.083		Acc.
26	74.10"		□ .03		74.084		Acc.
27	78.10"		□ .03		78.083		Acc.
28	82.10"		□ .03		82.084		Acc.
29	85.43"		□ .03		85.420		Acc.
30	88.01"		□ .03		88.000		Acc.
31	92.01"		□ .03		91.999		Acc.
32	96.01"		□ .03		96.000		Acc.

INSPECTION / TEST REPORT						JOB No.	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

33	100.01"		□ .03		100.000		Acc.
34	103.43"		□ .03		103.420		Acc.
35	108.42"		□ .03		108.409		Acc.
36	109.67"		□ .03		109.659		Acc.
37	112.17"		□ .03		112.158		Acc.
38	113.42"		□ .03		113.407		Acc.
39	113.92" o.a.		□ .03		113.907		Acc.
40	1.25" TYP	Section A-A, J-J	□ .03		1.260/1.269		Acc.
41	R.03" TYP		□ .03		.030		Acc.
42	R.02" TYP		□ .03		.020		Acc.
43	3.358"		+ .010/- .030		3.365/3.353		Acc.
44	R.13" TYP		□ .03		.125		Acc.
45	.32" TYP		□ .03		.320		Acc.
46	3.466"		+ .010/- .030		3.474/3.455		Acc.
47	R.13" TYP		□ .03		.130		Acc.
48	.080 TYP,REF		□ .03		.080		Acc.
49	1.37" TYP	Section B-B	□ .03		1.374/1.38		Acc.
50	R.03" TYP		□ .03		.030		Acc.
51	R.02" TYP		□ .03		.020		Acc.
52	3.358"		+ .010/- .030		3.343/3.362		Acc.
53	R.25" TYP		□ .03		.250		Acc.
54	.32" TYP		□ .03		.319		Acc.
55	R.25" TYP		□ .03		.250		Acc.
56	3.428"		+ .010/- .030		3.3436/3.4175		Acc.
57	1.80" TYP	Section C-C	□ .03		1.7985/1.806		Acc.
58	R.03" TYP		□ .03		.030		Acc.
59	R.02" TYP		□ .03		.020		Acc.
60	3.246"		+ .010/- .030		3.237/3.256		Acc.
61	R.25" TYP		□ .03		.250		Acc.
62	2.00" TYP	Section D-D	□ .03		1.983/1.988		Acc.
63	R.03" TYP		□ .03		.030		Acc.
64	R.02" TYP		□ .03		.020		Acc.
65	3.095"		+ .010/- .030		3.084/3.110		*
66	R.25" TYP		□ .03		.250		Acc.
67	2.00" TYP	Section E-E, F-F	□ .03		1.985		Acc.
68	R.03" TYP		□ .03		.030		Acc.
69	R.02" TYP		□ .03		.020		Acc.
70	3.026"		+ .010/- .030		3.042/3.010		*
71	R.25" TYP		□ .03		.250		Acc.

INSPECTION / TEST REPORT						JOB No.	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

72	1.96"	Section G-G	± .03		1.970		Acc.
73	R.03" TYP		± .03		.030		Acc.
74	R.02" TYP		± .03		.020		Acc.
75	3.157		+.010/-.030		3.146/3.172		*
76	R.25" TYP		± .03		.250		Acc.
77	1.82"	Section H-H	± .03		1.824/1.814		Acc.
78	R.03" TYP		± .03		.030		Acc.
79	R.02" TYP		± .03		.020		Acc.
80	3.238"		+.010/-.030		3.244/3.227		Acc.
81	R.25" TYP		± .03		.250		Acc.
82	1.48"	Section I-I	± .03		1.438		Acc.
83	R.03" TYP		± .03		.030		Acc.
84	R.02" TYP		± .03		.020		Acc.
85	3.358		+.010/-.030		3.349/3.364		Acc.
86	R.25" TYP		± .03		.250		Acc.
87	3.396"		+.010/-.030		3.411/3.386		*
88	R.25" TYP		± .03		.250		Acc.